

Date: Wednesday, 3/8/2006 10:38:02 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHROUD ASSEMBLY
Job Number	: 26112 -2		
Estimate Number	: 12198		
P.O. Number	: N/A	Part Number	: D346719
This Issue	: 3/8/2006 S.O. No. : N/A	Drawing Number	: D3467 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 3/31/2006
Checked & Approved By	: [Signature] 06.03.08	Qty:	20 Um: Each
Comment	: est rev. A 06.02.06 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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Comment: Sub-Contracting Issue P/O: 00000768 [Signature] 06/03/09
 Email or Ship DXF file to vendor
 Laser Cut per Dwg D3467 flat pattern D3467-19F
 Material release note required

2.0	D346719F	DOUBLER FLAT PATTERN
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 DOUBLER FLAT PATTERN

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

06.03.22 (20)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06.03.22 (14) PTO

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Form as per dwg D3467 using DT8852

06.03.25 (17)
 (14) PTO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		One taken for sample	JB	06/03/27	1	JB	JB

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/04/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/04/25	5	3 & rep	JB 06/04/25	destroy	JB 06/04/25	JB 06/04/24	JB 06/04/25	JB 06/04/25

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:38:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD ASSEMBLY

Job Number: 26112

Part Number: D346719

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/04/25

(14)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SB 06/04/25

(14)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/04/26

(14)

Job Completion



in 06-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

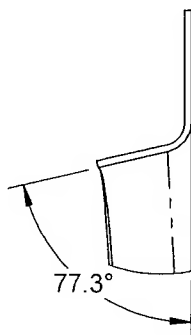
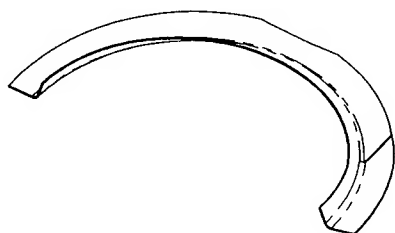
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

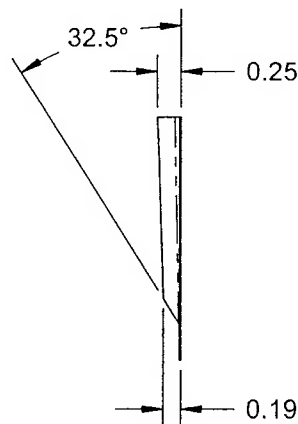
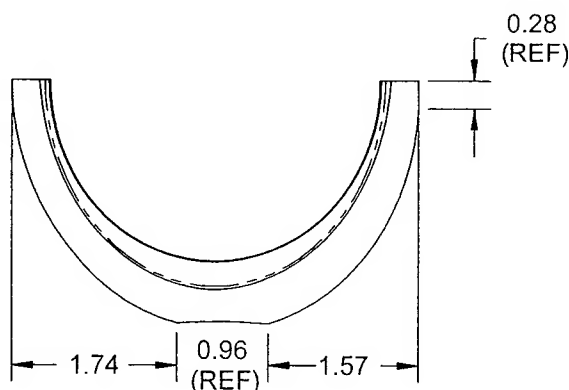
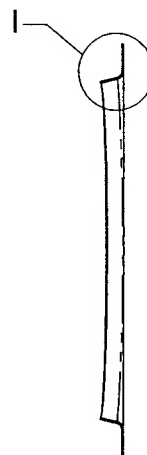
NOTE: Date & initial all entries

PRELIMINARY ISSUE

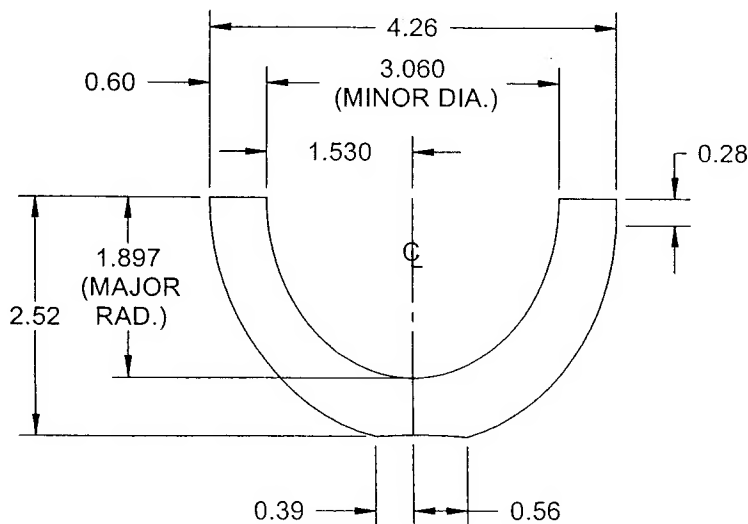
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3467	REV. A SHEET 15 OF 15
DATE 05.12.07	TITLE SHROUD ASSEMBLY		SCALE 1:2



DETAIL I
SCALE 1:2



D3467-19 DOUBLER, LH SHOWN
D3467-20 DOUBLER, RH OPPOSITE



D3467-19F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

Ryerson

FROM-INTERIS

F-126 P-007/015 F-587

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Page 1

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[illegible]

CHEMICAL ANALYSIS

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NO INTENTIONAL ADDITIONS OF MERCURY

IS CAPABILITY OF TRAINING OF THE

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THE UNIVERSITY OF MICHIGAN

WIN LINES ON NEAL FAN

Fax Server

T-726 P.008/015 F-527

002/004

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 1
Heat/Lot : 86K8
TIN : B42748

Sold To: INTEGRIS METALS, LTD.
7910 49TH STREET SE
CALGARY, AB T2C2Y3

Ship To: ***CUSTOMER PICKUP***
4375 14TH STREET NORTHEAST
CALGARY
ABT3E7A9

Vendor Information

Cust PO #: 406824

Cust PO DT: 11/03/05

Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a 480/04a, 666/03, ASMESA240/04-A05, 480/04-A05, SA666/04
Q08766D-A X 1/8 PRM, AMS5513H X MRK&FIN, MILS059D, AMD3, X CRWN MRAS
CORROSION: ASTM A262/02aB; 180Bend-OK
Buyer Part: 4288441
304 2B .1305 IN 48 IN 96 IN
Country of Origin: UNITED STATES

Mechanical Tests

		UOM	L	O		UOM	L	O
Yield Strength - 0.2% Offset	40	KSI	F	TRANSV				
Tensile Strength (UTS)	93.3	KSI	F	TRANSV				
Rockwell B	85		F	TRANSV				
Pct Uniform Elong 2 In/50mm	57.01	PCT	F	TRANSV				
Rockwell A	85		T	TRANSV				

Chemical Composition

C Carbon-Pct	.059	CR Chromium-Pct	18.360
CU Copper-Pct	.342	MN Manganese-Pct	1.643
MO Molybdenum-Pct	.285	N Nitrogen-Pct	.037
NI Nickel-Pct	8.150	P Phosphorus-Pct	.029
SI Silicon-Pct	.289		

Comments

03/17/2006 14:18 FAX 6042729137
04/20/2015 08:27 FAX

INTEGRIS METALS

004/004
002

The Chemical Analysis and Mechanical Test
data was received via EMI from the above
mentioned vendor.
INTEGRIS METALS, LTD.

5/17/06
20-28445-06 0/5
0880 01
52870: 17.6.0000

Date: 03/17/06

Control #: 51C60214
Part #: 74271441
135 X 48 X 96

Miscellaneous Data

QA by ERIC REAS 02/01/2006

Material from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex 1, Para. 4.3 0087638 cond A
This document certifies the material has been tested in
accordance with applicable specifications described herein
and has met those requirements.

Page : 2
Heat/Lot : 86K8
TIN : B42748

From: NORTH AMERICAN STEELWORKS CANADA, IN
740 INDUSTRIAL ROAD NORTH

MATERIAL TEST REPORT